



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3506-1**

**Job Sheet 177053**



**Part No:** D3506-1

**Job Qty:** 12 ea

**Part Name:** Doubler



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 5/4/18

**Job Tracking No:**

**Due Date:** 5/24/18

**Created By:** Michelle Gagnon-Donovan

**Type:** Stock

**Description:**

**Note:** DWG REV A IPP Rev:A New Issue 06-05-31 JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                        |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation     | 12 Ea  | 5/24/18    | 5/24/18  | 0.00      | 0.00    | Start Up Waterjet     |           | SC 18/05/18 |
| 100   | Waterjet               | 12 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.36    | Waterjet1             |           | SC 18/05/18 |
| 110   | QC                     | 12 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC2 Waterjet-2        |           | SC 18/05/18 |
| 120   | CNC Vertical Machining | 12 pcs | 5/24/18    | 5/24/18  | 0.05      | 0.95    | HAAS1-3               |           |             |
| 130   | QC                     | 12 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC2 Machining-2       |           |             |
| 140   | QC                     | 12 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC8 Machining-2       |           | SC 18/05/18 |
| 150   | Small Fab              | 12 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.22    | Small Fab-4           |           | JAS         |
| 160   | QC                     | 12 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC5                   |           | 38          |
| 170   | HandFinish             | 12 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.21    | HandFinish1           |           | SA 18-05-24 |
| 180   | QC                     | 12 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC7-2                 |           |             |
| 190   | Packaging              | 12 pcs | 5/24/18    | 5/24/18  | 0.00      | 0.00    | Packaging3-1          |           |             |
| 200   | QC21-SA                | 12 Ea  | 5/24/18    | 5/24/18  | 0.00      | 0.00    | QC21                  |           |             |

DAS JUN 05 2018

### Job BOM

| Part / Item  | Component Name     | Quantity            | Operation             | Container |
|--------------|--------------------|---------------------|-----------------------|-----------|
| M6061T6S.100 | 6061-T6 .100 Sheet | .0936 sf (.0078 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6S.100   | 0        | 44        | 0         |

### Part Specifications

Specifications could not be found.

Plex 5/4/18 12:50 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 813 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Container No: S070850



Part: D3506-1

Job No: 177053

Serial No/Batch: S070850

Revision:

Inspector:

Date: 05/12/18

35  
177

6-00  
24  
0-70

|                              |               |                             |
|------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b> 177053   |
| <b>Description:</b> Doubler  |               | <b>Part Number:</b> D3506-1 |
| <b>Inspection Dwg:</b> D3506 | <b>Rev:</b> A | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.128            | +0.005/-0.001 | Ø0.129           | 1      |        | VSC-01               |          |
| Ø0.404            | +0.006/-0.001 | Ø0.404           | 1      |        |                      |          |
| 0.750             | +/-0.010      | 0.749            | 1      |        |                      |          |
| 1.500             | +/-0.010      | 1.496            | 1      |        |                      |          |
| 0.375             | +/-0.010      | 0.373            | 1      |        |                      |          |
| 0.750             | +/-0.010      | 0.749            | 1      |        |                      |          |
| 0.250             | +/-0.010      | 0.248            | 1      |        |                      |          |
| 0.098             | +/-0.010      | 0.100            | 1      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
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|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                           |                                |                                |
|---------------------------|--------------------------------|--------------------------------|
| <b>Measured by:</b> SC 54 | <b>Audited by:</b> [Signature] | <b>Prototype Approval:</b> N/A |
| <b>Date:</b> 18/05/12     | <b>Date:</b> 18/05/12          | <b>Date:</b> N/A               |

| Rev | Date     | Change    | Revised by | Approved    |
|-----|----------|-----------|------------|-------------|
| A   | 07.03.09 | New Issue | KJ/JLM     | [Signature] |